

Date: Monday, 02/03/2009 9:04:55 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 46136	
Estimate Number : 10689	
P.O. Number :	Part Number : D34543
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3454 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 40932	Material :
Written By :	Due Date : 09/03/2009 Qty: 40 Um: Each
Checked & Approved By : <u>JUD 09.03.02</u>	
Comment : est rev. A 05.11.17 new issue EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M303R0750

303 Round Bar 0.750



Comment: Qty.: 0.0630 f(s)/Unit Total : 2.5200 f(s)
 303 Round Bar .75"

(M303R0750)

Batch: M10680

4 1/4 slip - end of bar
 (.354 ft)

SA 09/03/05 → 2.6 ft

2.0

HARDINGE

HARDINGE CNC LATHE SMALL

**Comment:** HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA571 & DWG D3454 ,

FOLIO REV: N/ADWG REV: 13

2-DEBURR AS REQUIRED

SA 09/03/05

(40)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/03/05

(40)

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

ml 09/03/06

(40)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Debur if necessary.

SA 09/03/05

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:04:55 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 46136

Part Number: D34543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

center
5/26/06 (X40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST94

18 09/03/06 (X40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/06

Job Completion



MF
09-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

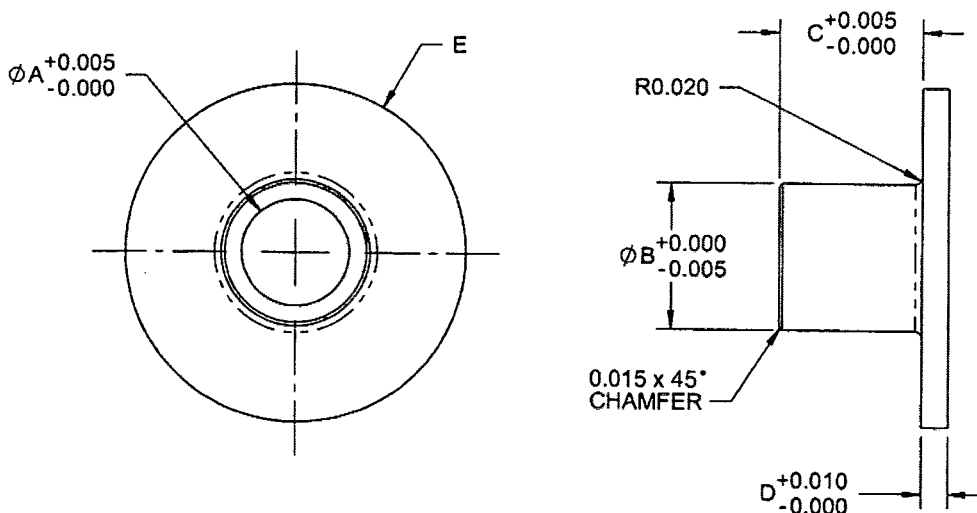
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3454	REV. B SHEET 1 OF 1
DATE 05.12.05		TITLE BUSHING	SCALE 2:1
A	05.09.02	NEW ISSUE	
B	05.12.05	REVISE -5/-7	

RELEASED

05.12.05 *[Signature]*



D3454-X

1) SPECIFICATION: D3454-X BUSHING

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *44136*

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.